



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3135-041

Job Sheet 198436



Part No: D3135-041

Job Qty: 2 pcs

Part Name: Handle Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/29/19

Job Tracking No:

Due Date: 9/3/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG REV D IPP: A 03.03.06 New Issue KJ/RF IPP Rev:B 08-01-15 now on water jet DD IPP Rev:C 08-05-22
revD as per dwg ECN1192 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		9/3/19	0.17	0.37	Waterjet - Flow	8/16/19	JRB
110	QC 2	2 pcs		9/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

SCRAP



Container No: S206498



Part: D3135-041

Job No: 198436

Serial No/Batch: S206498

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/03/20

120 QC 8	2 pcs	9/3/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	AUG 22 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - 2 - B4B	2 pcs	9/3/19	0.00 1.25	Small Fab - 1 - B4B	DAS 40 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	2 pcs	9/3/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	FFD 27 2020
				QC 5 - 61	
				QC 5 - 81	
150 Large Fab - Welded Assy-2-B4B	2 pcs	9/3/19	0.00 0.67	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	MV/MAS 2/20
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

DAS
28
9-89

210 QC 21 - SA

2
pcs

9/3/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

DAS
21 MAR 05 2020

5T202

Part Op 100 - 1-Cut as per Dwg D3135 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1-Bend D3135-1 as per template D3135-1T2 and Dwg D3135 2-Deburr ends

140 - QC5- Inspect part completeness to step on W/O

150 - (Fabricate per Dwg), 1-Weld handle onto plate as per Dwg D3135 and QSI 004 304 S.S. welding rod

Batch: M139028

160 - QC9- Inspect visual per QSI004- Fusion Welds

170 - QC5- Inspect part completeness to step on W/O

180 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: 10:10 OVEN TEMPERATURE: 320°FINISH TIME: 10:40

190 - QC3- Inspect Part Finish

200 - (Identify as per dwg & Stock Location: _____), Location : CA2

210 - QC21- Final Inspection - Work Order Release

5138839

Job BOM

Job BOM records could not be found.

DAS
03
9-89

M304S166A

~~M304S166A~~

Job Allocations

150 M304TRO.375W.065

.4167

Job Allocations could not be found.

5200442

5244042

Part Specifications

Specifications could not be found.

Plex 7/29/19 1:11 PM Dart.Renwick.Jennifer



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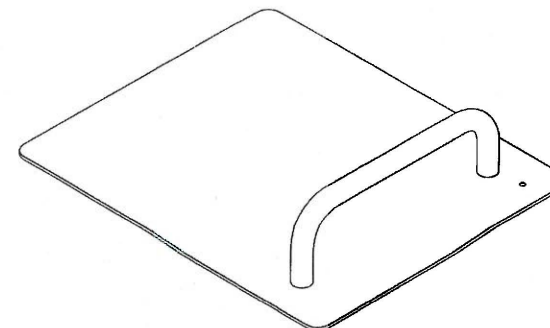
Exp Date:

Instructions: Various STC's

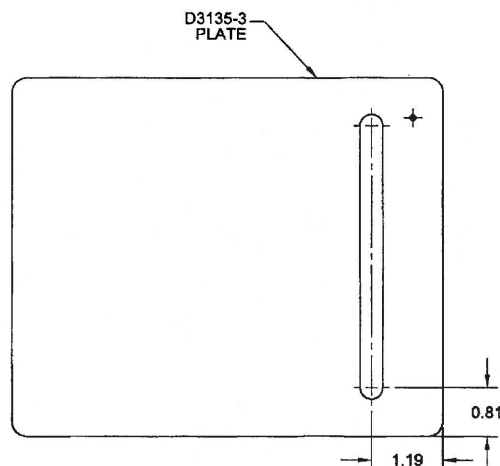
Date: 08/18/19

QTY. -041	PART NUMBER	DESCRIPTION
X	D3135-041	HANDLE WELDMENT
1	D3135-1	HANDLE
1	D3135-3	PLATE

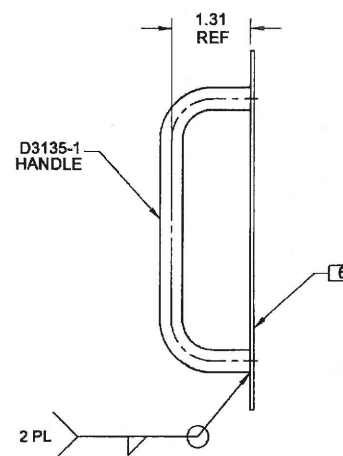
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198436



D3135-041 HANDLE WELDMENT



D3135-041 HANDLE WELDMENT

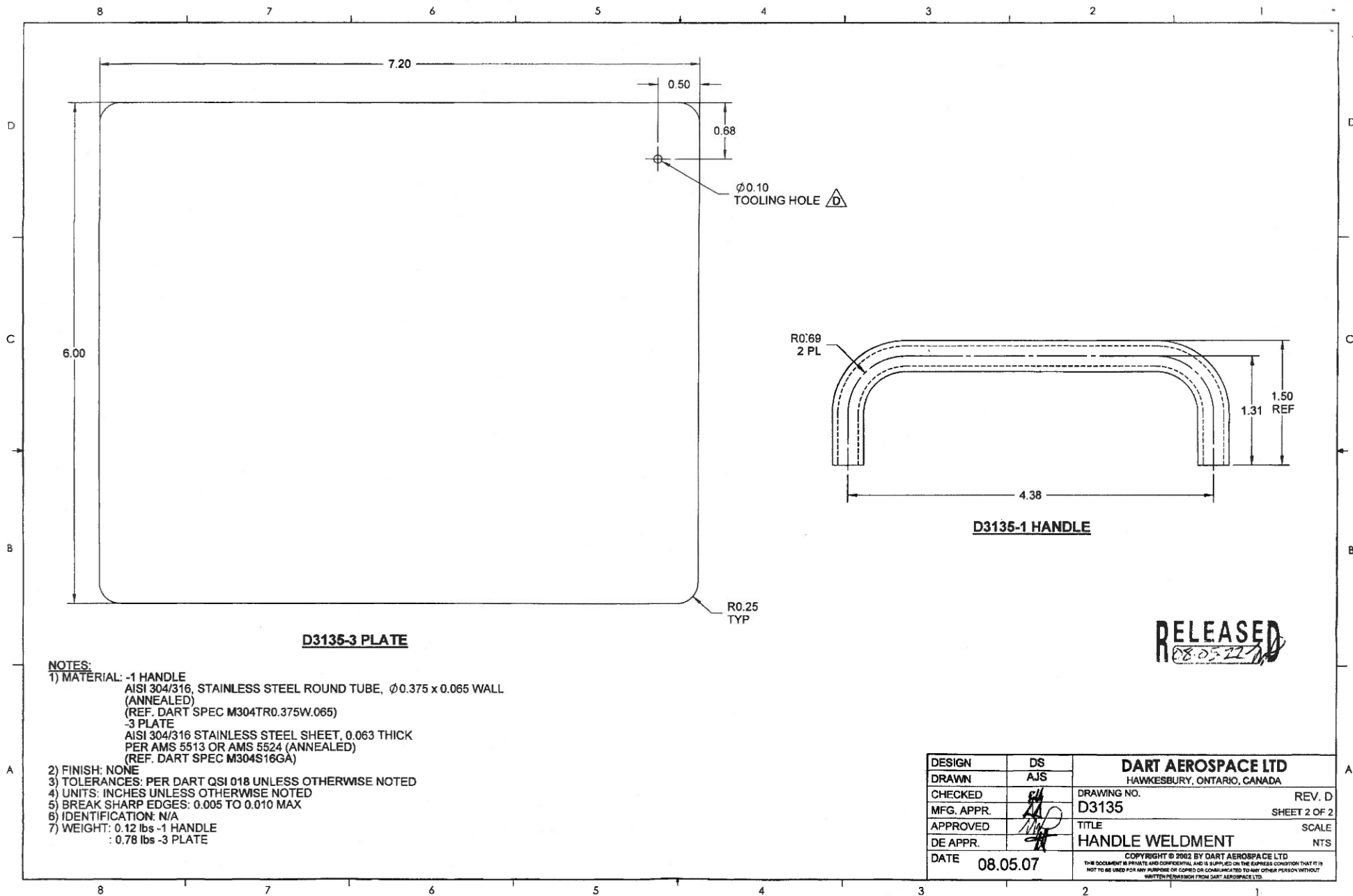


RELEASED
08-05-07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT COLOUR GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3135-041" AND BATCH "BXXXXX" USING FINE POINT PERMANENT INK MARKER OR FIX LABEL AFTER FINISHING
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004

D	REDRAWN TO SOLIDWORKS FORMAT. ZN D4-2 TOOLING HOLE ADDED. REASON: PRODUCTION REQUEST FOR TOOLING HOLE.	AJS	08.05.07
C	REMOVED Ø0.221 HOLES	DS	04.10.06
B	6.400 WAS 6.330; ADD "ANNEALED"	DS	03.03.04
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3135	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HANDLE WELDMENT	NTS
DATE	08.05.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Entered: 2R Date: FEB 03 2021



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 21-8828

Route update only ☐

Job: <u>198436</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D3135-041</u>		Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
		Scrap ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☒	
		Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐	
Date: <u>AUG 22 2019</u>		Sequence #: <u>120</u>		QTY Affected: <u>1 of 7</u>		MRB (QSI042) DAS 55 9-89 JUN 29 2020	
Description Work Order Deviation			Disposition			Completed By 40 9-89 AUG 22 2019	
<u>- part moved on waterjet while cutting</u>			<u>- Scrap</u>			Lead hand / Supervisor <u>JmB</u> <u>19/8/22</u>	
Root Cause			FAULT CATEGORY				
Operator ☒	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☒			
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details:						